

Ship 15/10

41

Date: Wednesday, 10/3/2007 8:38:55 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 34984	
Estimate Number : 13041	
P.O. Number : NA	Part Number : D2127251025
This Issue : 10/3/2007 S.O. No. : N/A	Drawing Number : D2127251 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : N/A	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 10/9/2007
Checked & Approved By : <u>[Signature]</u>	Qty: <u>5</u> Um: Each
Comment : Est. <u>A</u> New Issue 07-10-02 DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1500W125	6061T6 TUBE 1.500X .125W
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Comment: Qty.: 0.4337 f(s)/Unit Total : 4.3365 f(s)  
6061T6 TUBE 1.500X .125W  
Batch: M18639

DJP 07/10/05

(5)

2.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE  
1-Turn as per Dwg D212-725-1

2-Deburr

DJP 07/10/05

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 07/10/05

(5)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

vr 07/09/05

(5)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

ll 07-10-05

(5)

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/10/11 5x 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
2							
2							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   D   Date: 07/15/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 10/3/2007 8:38:55 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 34984

Part Number: D2127251025

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

2/10/11

50

57

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

2/10/12

Job Completion



U 07-10-12

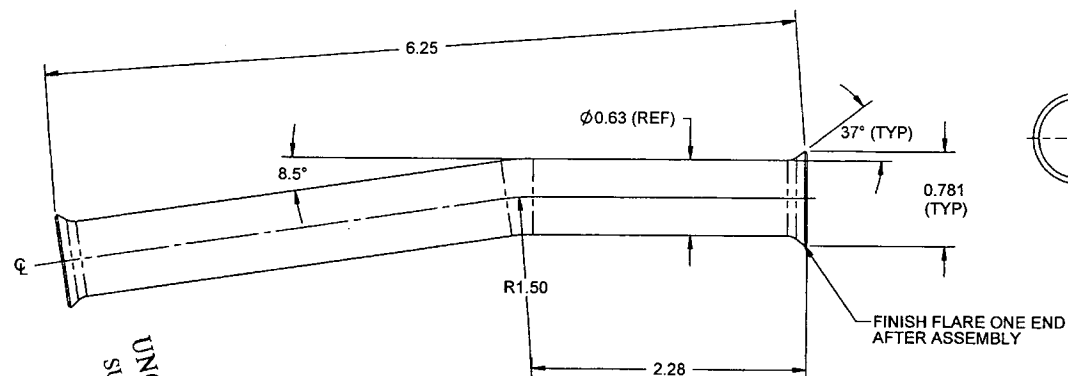
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

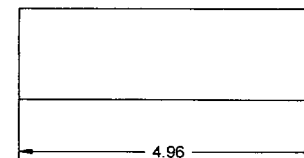
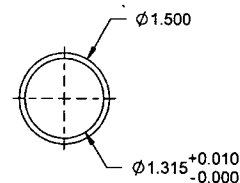
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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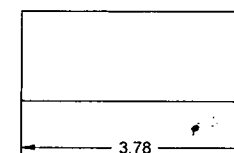
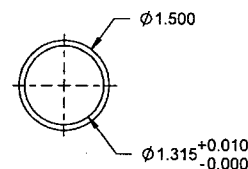
**NOTE:** Date & initial all entries



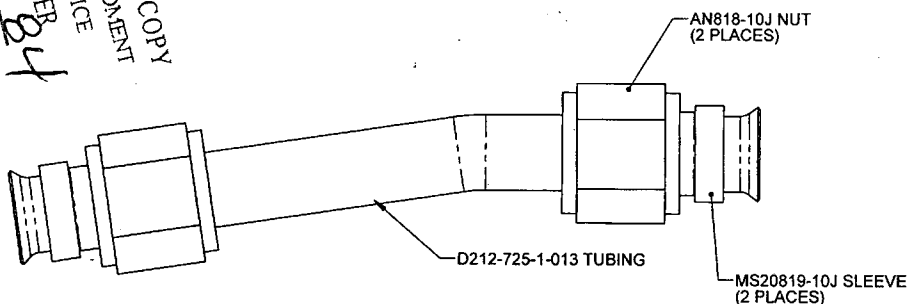
**D212-725-1-013 TUBING**  
MANUFACTURE PER TEMPLATE DT8906



**D212-725-1-025 SPACER**  
SCALE 1:2



**D212-725-1-027 SPACER**  
SCALE 1:2



**D212-725-1-903 TUBE ASSEMBLY**

**D212-725-1-025/-027 NOTES:**

- 1) MATERIAL: 6061-T6 OR 6061-T62 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM (REF. DART SPEC. M6061TX.XXXW.XXX OR M6061T6R)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

**D212-725-1-013 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBING 0.625 O.D. x 0.035 WALL (REF. DART SPEC. M304TR0.625W0.035)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN DC	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED 	DRAWING NO. <b>D212-725-1</b> REV. B SHEET 6 OF 44
DATE <b>07.05.11</b>	TITLE <b>212S DETAIL PARTS</b>	SCALE 1:1
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NO. 34984

